

Work Order ID 54965

January 5, 2010 11:19:40 AM



Page 1

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *RL*

Date: *10-1-05* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

8/10/01/11

HJ for BG 10/01/11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-11 (2x) SD

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

=> 8/10/01/11

(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54965

January 5, 2010 11:19:40 AM

Page 2

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-011

Location: 60

REV B

10-1-11 (2) SP

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/12

MF 10-1-012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 11:19:46 AM

Page 1

Work Order ID: 54965

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH



Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-141  Bracket Assembly		Manufactured	No			100	Each	0.0000	6.0000		10-1-11 SP	547588
D3121-143  Bracket Assembly		Manufactured	No			110	Each	3.0000	2.0000		10-1-11 SP	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

52365

3

3

110

Each

2.0000

2.0000

2
10-1-11 SP

D3183-043



Bracket Assembly

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

54219

2

2

110

Each

17.0000

2.0000

2
10-1-11 SP

D3137-043



Bracket Assembly

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42192

17

17

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 11:19:46 AM

Work Order ID: 54965

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------	---------------------	------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

D3199-1		Manufactured	No			110	Each	44.0000	18.0000			
---------	--	--------------	----	--	--	-----	------	---------	---------	--	--	--



8
+2 Bracket

10-1-11 sf

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

44

47848

2

53036

42

D3202-1

Manufactured No



8
+2 Cover

110

Each

20.0000

2.0000

18

10-1-11

(2x) sf

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

20

50134

20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW